



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RBW109-3130-70-101

Job Sheet 196742



Part No: RBW109-3130-70-101

Job Qty: 3 pcs

Part Name: Tail Rotor Pitch Change Housing Duplex, Bearing Removal



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/20/19

Job Tracking No:

Due Date: 8/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17220

Note: DWG RBW109-3130-70-101 Rev.2 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	3 pcs	8/20/19		0.00	3.00	Small Fab - 1		
							Small Fab - 2		MLL
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	3 pcs	8/20/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	3 pcs	8/20/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S193598



Part: RBW109-3130-70-101

Job No: 196742

Serial No/Batch: S193598

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
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Date: 06/25/19

DAS
40
9-89

JUN 25 2019

DAS
28
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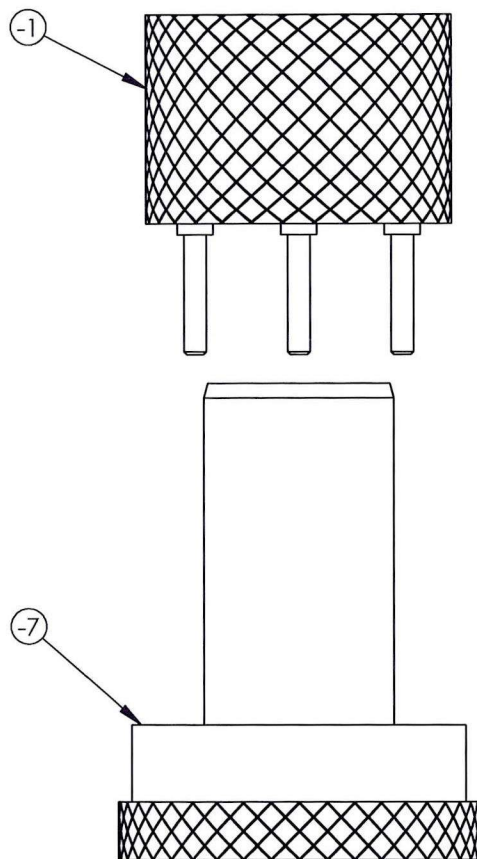
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	3 pcs	8/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
Part Op 110 - (Small Fab) 1-Assemble as per DWG. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					DAS JUN 26 2019 70 9-89 GA137A
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBW109-3130-70-101-1	Barrel Assembly	3 pcs (1 ea)	110-Small Fab - 1	5132024	
RBW109-3130-70-101-7	Base	3 pcs (1 ea)	110-Small Fab - 1	5130907	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	RBW109-3130-70-101-1	3	3	0	
	RBW109-3130-70-101-7	3	3	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. REMOVED T/N'S FROM BOM. UPDATED TITLE BLOCKS. -3 ADDED .03 X 45° CHAMFER TO PRESS FIT PIN. -7 CH'D TO 1 PEICE WAS ASSY. DELETED -9 & -11.	10/17/2013	CFS	RW
2	-3 CH'D DIM WAS 1.260 IS 1.254, WAS .115 IS .118. ADDED CHAMFER WAS .03 X 45° IS 2X .03 X 45°. -5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX. ADDED ENGRAVE "RBW109-3130-70-111". -7 CH'D CHAMFER WAS .15 X 30° IS .15 X 15°. CH'D DIM'S WAS 3.93 IS 4.93, WAS 2.925 IS 3.93, WAS 2.515 IS 3.54, WAS Ø2.95 IS 2.954. ADDED 2X R.015 MAX.	4/17/2014		



RED BARN MACHINE

TITLE TAIL ROTOR PITCH CHANGE HOUSING
DUPLX BEARING REMOVAL

DWG NO. RBW109-3130-70-101

REV
2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	BARREL ASSY			2
	3		-3		PIN	4140 Q & T	Ø3/8 X 2	3
	1		-5		BARREL	6061	Ø3-1/4 X 2-1/4	4
			-7	1	BASE	6061	Ø3-3/4 X 5-1/8	5
ASSY	-1							

MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	HEAT TREAT FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AW109
SCALE 1:2	DATE 4/5/2011
	SHEET 1 OF 5